

Work Order ID 75134

75134

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October-17-11 3:44:25 PM

Item ID: D3276-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Baffle Assembly RH
 Start Date: 17/10/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3276	Rev B								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3276 Dwg Rev: B Prog Rev: B 2-
6061 . 040 Deburr if necessary
B 11-10-18
(4)

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control
B 11-10-18

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control
S. ulio 19
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00	SP	11/10/02					
Small Fab	1-Deburr2-Roll as per Dwg D3276								
140		0.00							
140	NC BRAKE								
Brake NC	Memo	0.00	SP	11/11/02					
Brake NC	Form as per Dwg D3276								
150		0.00							
150	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

11-11-02 (4)

W/O:		WORK ORDER CHANGES					
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 Required Date: 04/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									

170	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
170									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 7:40								
	FINISH TIME: 8:10								

180	QC3- Inspect Part Finish	0.00							
180									
QC	Memo	0.00							
Quality Control									

Handwritten notes and signatures:

- 4 BR 11-11-3
- 4XØ m-11/11/08
- 4 Rlt & M 11/11/08
- covered

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Required Date: 04/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190		0.00							
190	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3276								
200		0.00							
200	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
210		0.00							
210	Identify as per dwg & Stock Location: <u>175</u>								
Packaging	Memo	0.00							
Packaging									

EP 11/11/08 (4)

(+4) 012

11/11/08 (42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

4

4

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Reject Number	Insp. Stamp
------------------	----------------

0.00

220

QC

Memo

0.00

Number Stamp
11/11/09
mx
11-11-09

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Picklist Print

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Work Order ID: 75134

75134

Parent Item: D3276-042

D3276-042

Parent Item Name: Baffle Assembly RH

Start Date: 17/10/2011

Required Date: 04/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-12-06 JLM
IPP Rev:B Now on Waterjet 06-09-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3276-3 *D3276-3* Decal		Manufactured	No			110	Each	13.0000	1	4			
**													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST045				13					
				56593				3					
				59694				10					
D2464 *D2464* 3/4 Seal		Manufactured	No			190	f	302.1000	2.25	9			
**													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST404				302.1					
				61878				302.1					
M6061T6S.040 *M6061T6S 040* 6061-T6 .040 Sheet		Purchased	No			190	sf	86.8000	1.0205	4.296842			
**													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT021				86.8					
				113004				7.5					
				117653				79.3					

ES 11/11/08

ES 11/11/08

(4)

B1110-18

117653

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Dart Aerospace Ltd

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